

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026696**Date Inspected:** 11-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**13W/14W "D" Plate**

This QA observed, at random intervals, an ABF/JV qualified welder, Rory Hogan #3186, performing Submerged Arc Welding (SAW) and implementing Caltrans approved Welding Procedure Specification (WPS)

ABF-WPS-D15-4042B-1. Welding was performed at the 30/35mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "D" bottom plates. Welding operations were performed from approximately Y=6500mm~8500mm. This weld is a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=555, V=33.1, T=365).

This QA observed, at random intervals, an ABF/JV qualified welder, Jeremy Dolman #5042, performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS)

ABF-WPS-D15-3200-2. Welding was performed at the 30/35mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "D" bottom plates. Welding operations were performed from approximately Y=0001mm~2500mm. This weld is a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=223, V=23.1, T=300).

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## WELDING INSPECTION REPORT

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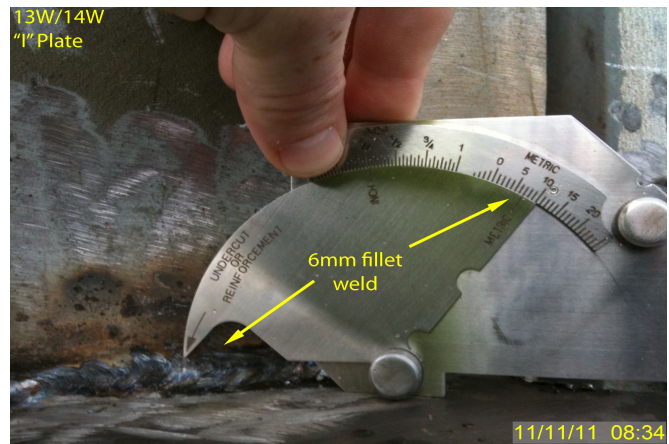
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### 13W/14W "T" Plate

Approximately 8:00 this QA randomly observed ABF/JV personnel had previously welded two (2) "strong back" type temporary attachment fitting aids to joint 13W/14W "T" plate. The strong back fitting aids consisted of two (2) 25mm thick plates attached at both sides of the weld joint with 6mm fillet welds at the top and bottom sides of the plate. These fillet welds are approximately 120mm in length. See attached photograph for visual representation.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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